

PREMIARC™ DW-312

80%Ar - 20%CO₂
 EN ISO 17633-A T 29 9 R M 3
 AWS A5.22 E312T0-4
 EN 1.4337

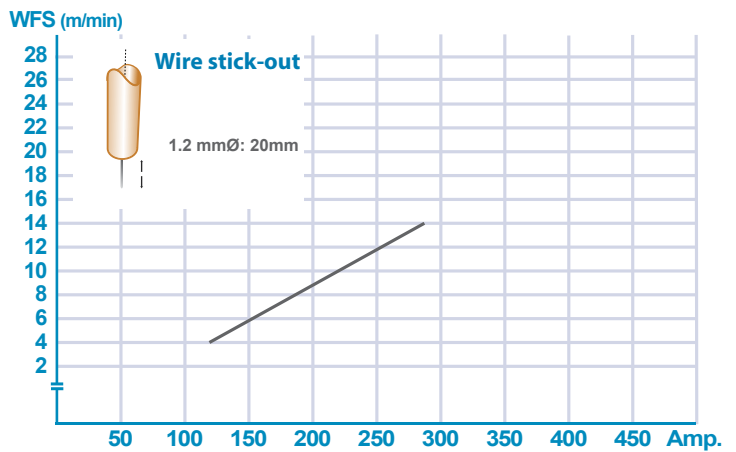
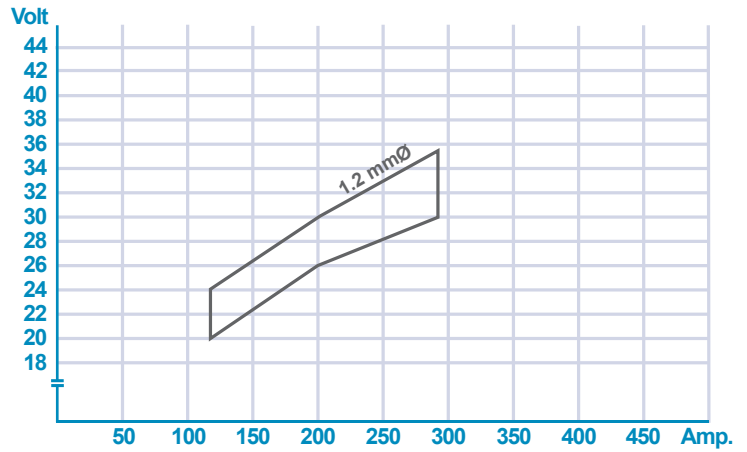
Description and Application

This rutile flux cored wire welds with a stable and almost spatter free arc to produce a shiny, bright, smooth weld bead surface with self-releasing slag.

Excellent crack resistance is due to a combination of high alloy and high ferrite content, which gives extreme tolerance to dilution on a wide range of hardenable and alloy steels with minimum or no preheating. The weld deposit also work-hardens and provides good wear and friction resistance.

PREMIARC™ DW-312 is applied for welding medium and high carbon hardenable steels, of known or unknown specifications, for example tool steels, shafts, free-cutting steels, dissimilar alloy combinations, overlaying, buffer layers prior to hard facing.

Recommended Parameter Range, for flat position*



Typical Chemical Analysis (wt. %)*

| C | Si | Mn | P | S | Ni | Cr | Mo | N | Nb | FS | FN | FNW |
|------|------|------|-------|-------|------|------|----|---|----|------|-------|------|
| 0.12 | 0.60 | 1.20 | 0.018 | 0.006 | 10.2 | 28.4 | - | - | - | 60.0 | >18.0 | 50.7 |

Typical Mechanical Properties*

| | R _e (MPa) | R _m (MPa) | A ₅ (%) | CV (J) 0°C |
|-----------|----------------------|----------------------|--------------------|------------|
| Guarantee | 580 | 740 | 23 | - |
| | min.450 | min.660 | min.15 | |

Welding Positions



Approvals

| LR | DNV | BV | GL | ABS | R.M.R.S | Others |
|----|-----|----|----|-----|---------|--------|
| - | - | - | - | - | - | - |